

D4131-3

Work Order ID 108986 B108986

October-31-13 12:48:19 PM

108986

Page 1

Item ID: D4131-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Base

Start Date: 10/31/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/14/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: M5

Date: 10-10-31

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4131	B	0.00							
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
304-050	Dwg Rev: B								
	Prog Rev: B								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

10 0 Jm3-11-23

Jm3-11-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS															
Part No. _____ NCR No. _____			Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Quality <input type="checkbox"/>	Other <input type="checkbox"/>									
			Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>											
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector										
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved																					
FAULT CATEGORY																					
Landing Gear				<table border="0" style="width: 100%; border-collapse: collapse;"> <tr> <td colspan="4" style="padding: 5px;">General</td> </tr> <tr> <td style="vertical-align: top; padding: 5px;"> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube </td> <td style="padding: 5px;"> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function </td> <td style="padding: 5px;"> <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence </td> <td style="vertical-align: top; padding: 5px;"> <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge </td> <td style="vertical-align: top; padding: 5px;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled </td> <td style="vertical-align: top; padding: 5px;"> <input type="checkbox"/> Other </td> </tr> </table>								General				<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Other
General																					
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Other																

Work Order ID 108986

October-31-13 12:48:19 PM

108986

Page 2

Item ID: D4131-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Base

Start Date: 10/31/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/14/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

DAS

27

9-89

10
11/125

120

QC

Quality Control

130

Bend as per dwg

0.00

DAS
30
9-89

10

11/127

130

Brake NC

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

DAS

27

9-89

10
11/127

140

QC

Quality Control

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging	Engineering Quality Other				
Part No. _____ NCR No. _____											
Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced							
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up							
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure							
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld							
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled							
Crushing	Countersink	Misaligned/off center	Positioned Wrong								
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge								
Inspection Strip in Tube	Drawing	Misread									
Marks/Chatter	Drill Holes	Off-set									
Turning Sequence	Finish	Out of Calibration									
Wave/Twist in Tube	Fit/Function	Out of Sequence									

Work Order ID 108986

October-31-13 12:48:19 PM

108986

Page 3

Item ID: D4131-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Base

Start Date: 10/31/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/14/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: STO96

0.00

10X

DAS
28
9-89

13-11-27

150

Packaging

Packaging

Memo

0.00

160

QC21- Final Inspection - Work Order Release

0.00

13/11/29 JF

160

QC

Quality Control

Memo

0.00

MK
13-11-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending	<input type="checkbox"/>		Bend	<input type="checkbox"/>		Folio/Program	<input type="checkbox"/>		Outside Dimensions	<input type="checkbox"/>	Pressure/Forced
Centre Not Concentric	<input type="checkbox"/>		BOM/Route	<input type="checkbox"/>		Grain	<input type="checkbox"/>		Over/Under tolerance	<input type="checkbox"/>	Set-up
Cracks	<input type="checkbox"/>		Broken/Damage/Defect	<input type="checkbox"/>		Hardware	<input type="checkbox"/>		Part Incorrect	<input type="checkbox"/>	Temperature/Cure
Crimp/Kink/Ripple/Wave	<input type="checkbox"/>		Burrs	<input type="checkbox"/>		Inspection Incomplete/Unqualified	<input type="checkbox"/>		Part Lost/Missing	<input type="checkbox"/>	Weld
Cuffs	<input type="checkbox"/>		Contamination	<input type="checkbox"/>		Instructions Incomplete/Unclear	<input type="checkbox"/>		Part Moved	<input type="checkbox"/>	Wrong Stock Pulled
Crushing	<input type="checkbox"/>		Countersink	<input type="checkbox"/>		Misaligned/off center	<input type="checkbox"/>		Positioned Wrong	<input type="checkbox"/>	
Heat Treat	<input type="checkbox"/>		Cut Too Short	<input type="checkbox"/>		Mislabeled	<input type="checkbox"/>		Power Loss/Surge	<input type="checkbox"/>	Other
Inspection Strip in Tube	<input type="checkbox"/>		Drawing	<input type="checkbox"/>		Misread	<input type="checkbox"/>			<input type="checkbox"/>	
Marks/Chatter	<input type="checkbox"/>		Drill Holes	<input type="checkbox"/>		Off-set	<input type="checkbox"/>			<input type="checkbox"/>	
Turning Sequence	<input type="checkbox"/>		Finish	<input type="checkbox"/>		Out of Calibration	<input type="checkbox"/>			<input type="checkbox"/>	
Wave/Twist in Tube	<input type="checkbox"/>		Fit/Function	<input type="checkbox"/>		Out of Sequence	<input type="checkbox"/>			<input type="checkbox"/>	

Picklist Print

Page 1

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Work Order ID: 108986

108986
D4131-3

Parent Item: D4131-3

Parent Item Name: Base

Start Date: 10/31/13

Required Date: 11/14/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	319.3774	0.1614	2			

M304S18GA

304/316 .050 Sheet

Jm 3-11-23

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT019	166.45001	
117188	3.88	
117766	5	
120604	5	
122325	3	
123155	3	
124572	0.00001	
M126647	146.57	
MAT020	152.92742	
120243	0.928	
121626	1.529894	
124029	84.046526	
M126098	66.423	

125552

125552.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

<p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
---	--	---	--

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General				Fault Category				
Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube	Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function <input type="checkbox"/>	Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other <input type="checkbox"/>					

DART AEROSPACE LTD	Work Order:	108986
Description: Base	Part Number:	D4131-3
Inspection Dwg: D4131	Rev: B	Page 1 of 1

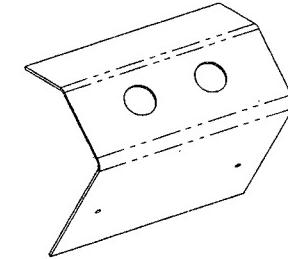
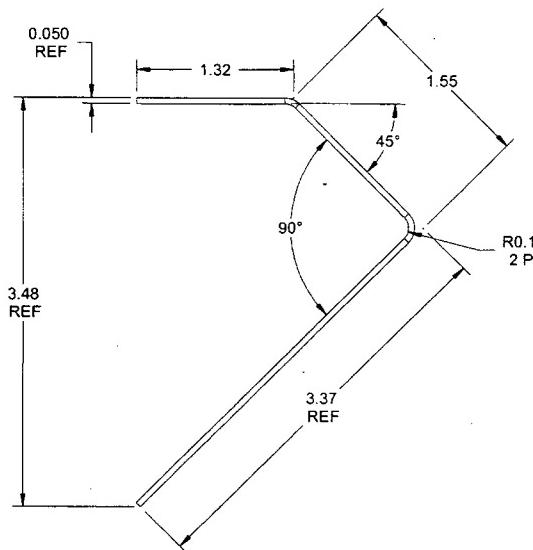
FIRST ARTICLE INSPECTION CHECKLIST

DAC
PAN

Measured by:	Jun	Audited by:	27 9.89	Preliminary Approval:	
Date:	13-11-23	Date:	13/11/23	Date:	.

Rev	Date	Change	Revised by	Approved
A	10.10.25	New Issue	KJ	
B	12.03.08	Dimensions updated per Dwg Rev B	KJ	
C	12.05.15	Dimensions added per Dwg Rev B	KJ	<i>[Signature]</i>

8 7 6 5 4 3 2 1



D4131-3 BASE
MAKE FROM D4131-3F FLAT PATTERN

108986 MUS
131031

RELEASED
2011-09-21
WIP

D

C

B

A

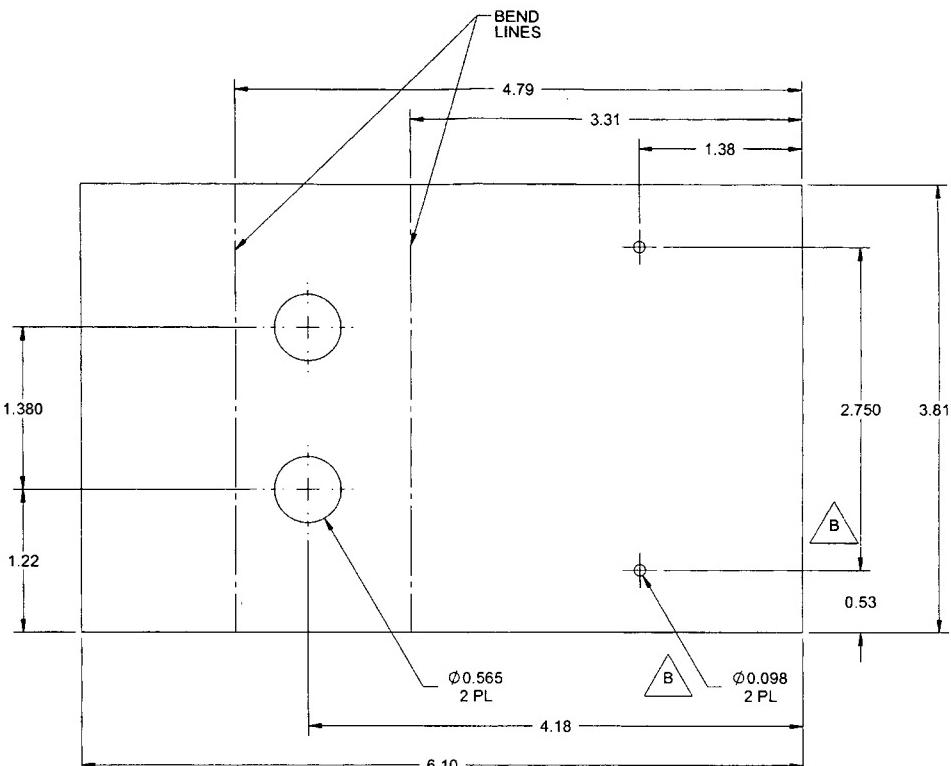
NOTES:

- 1) MATERIAL: MAKE FROM D4131-3F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

8 7 6 5 4 3 2 1

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>140</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>140</i>	D4131	SHEET 6 OF 10
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	MANIFOLD ASSEMBLY	NTS
DATE	11.07.27	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. THE DRAWING IS THE CONFIDENTIAL PROPERTY OF THE OWNER/CONTRACTOR THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

108986

D4131-3F FLAT PATTERN

RELEASED
2011-09-21
VV

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	RF	KENT, WA
CHECKED	<i>✓</i>	DRAWING NO. D4131
MFG. APPR.	<i>✓</i>	REV. B
APPROVED	<i>✓</i>	SHEET 7 OF 10
DE APPR.	<i>✓</i>	TITLE SCALE
		MANIFOLD ASSEMBLY NTS
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